Work	Order II)	618	326
Tuesday,	September 0	7,	2010	3:12



Page 1

Tuesday, Septem	ber 07, 2010	3:12:34 PM											
Revision ID:	D3763-1			Accept					Setup	Start Stop			
	End Fitting	64 12.00	1100101410101101101101							Stop			
Start Date: Required Date:	9/7/2010 9/13/2010	Start Qty: 12.00 Req'd Qty: 12.00	4 14 1 1 1 1 1 1 1		Cust Item Customer:								
Reference:			1 100101 11011 1101	I									
Approvals:	Process Plan	n:	Date/0-9-07	Tooling:	D	ate:			Run	Start			
	QC:	/(_ Date:	SPC (Y/N):	D	ate:				Stop			
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp	
Draw Nbr	Revi	ision Nbr											
D3763	Rev	В											
Doosan Lathe		DOOSAN LATHE Memo 1- Turn as per dwg D3	per Folio FA750 Rev:	0.00 0.00 & Dwg D3763 Rev: ∠	D 10 . 9 15 □2-Deburr	-29							-
		QC2- Inspect parts off r	machine FAI/FAIB	0.00	uf 10.9	- 29		12					
QC Quality Control		Memo		0.00						,			.,,
		QC8- Inspect parts - sec	cond check	0.00	15/89/2) 29							
QC Quality Control		Memo	•	0.00									_

Quanty Contro

Dart Ae	rospace	Ltd							•			
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
· · · · · · · · · · · · · · · · · · ·												
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	\:	Date:				
	Re	solution:	Disposition	ı :	_ QA: N/C C	losed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	7)						
5.455		Description of NC		Corrective Action Section	on B	Verific	ation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Section		Chief Eng	QC Inspector			
					ļ							
		•										

Work Order ID 61826

Required Date: 9/13/2010

Page 2

Tuesday, September 07, 2010 3:12:34 PM

Item ID:

Revision ID:

D3763-1

End Fitting

Item Name: **Start Date:**

9/7/2010

Start Qty: 12.00 Req'd Qty: 12.00

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

SPC (Y/N):

Set Up/

Tooling:

Accept

Run Hours

Run

Start

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: [CA]

Date:_____

0.00

0.00

Tool ID

Date:

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

QC Quality Control QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

10/09/309/J-MK 10-9-30

W/O:			W	ORK ORDER CHANG	ES		·		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								. rou mg	
······································							· · ·	*	
									,
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	lo DQA		Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C:Cĺo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		Verifica	ation	Approval	Approval
	J. Z.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio	n C	Chief Eng	QC Inspector
					·				

Picklist Print

Tuesday, September 07, 2010 3:12:41 PM

Work Order ID: 61826

Parent Item:

D3763-1

Parent Item Name: End Fitting



Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

08-05-23 new issue

DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000-		Purchased	No	- • .	. to to	100	f	3.6800	0.125	1.578947	,		
										w	10 a	2.	7

113457

ROUND BAR 1.00"

Location Loc Qty Loc Code MAT013 3.68 108876 3.38

0.3

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										`
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: `	/es N	io DQ	A:	Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	ICR)				
DATE	0750	Description of NC		Corrective Action Secti			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	41826
Description: Fitting	Part Number:	D3763-1
Inspection Dwg: D3763 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

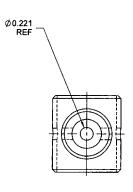
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.030	. 50C			Verneir in	less oflerwise
+0.000/ <u>-0.01</u> 0				speifie	1.
+0.005/-0.001	.201				
+/-0.030 x +/-0.5°	05 245				
+/-0.010	,540				
+/-0.010	1.091				
+/-0.010	- 580			Led sage	_
+0.000/-0.010	· 856			00	
			-		
		***	-		
	+/-0.030 +0.000/-0.010 +0.005/-0.001 +/-0.030 x +/-0.5° +/-0.010 +/-0.010	Tolerance +/-0.030 SAG +0.000/-0.010 20/ +0.005/-0.001 20/ +/-0.030 x +/-0.5° 05 > 45 +/-0.010 540 +/-0.010 580 +0.000/-0.010 856	Tolerance +/-0.030 +0.000/-0.010 +0.005/-0.001 +/-0.030 x +/-0.5° -/-0.010 +/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010	Tolerance +/-0.030 +0.000/-0.010 +0.005/-0.001 +/-0.030 x +/-0.5° -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010	Tolerance Dimension Accept Reject Inspection +/-0.030

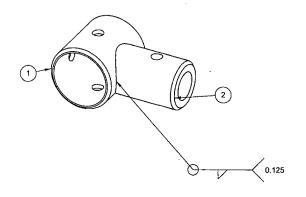
Measured by:	Audited by:	Preliminary Approval:
Date: 10 . 9 - 29	Date: 10/09/19	Date:

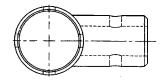
Rev	Date	Change	Revised by	Approved
Α	08.09.04	New Issue	KJ/DD IA	
В	10.06.07	Dimensions revised	KJ OK	<u>- </u>
			1//	•

	-							
W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
 							1	1
Part No		PAR #:						
	Re	esolution:					Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC			ion B Sign &	Verification		Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
		• •						

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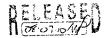






ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY



В.	CHANG	E HOLES SIZE	ADD -7 PART AND -045 ASSY	HS	08.06.23		
Α	NEW IS	SUE		HS	08.06.04		
REV.	DESCRIPTION			BY	DATE		
DESIG	N	HS	DART AEROSI	ACEL	TD		
DRAW	N	HS	HAWKESBURY, ONTARIO, CANADA				
CHECK	KED	Ref	DRAWING NO.		REV. B		
MFG. A	APPR.	Δ	D3763		SHEET 1 OF 9		
APPRO	OVED	7M	TITLE		SCALE		
DE AP	DE APPR.		END FITTING	M			
DATE 08.06.23			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS COCUMENT IS REMAYER AND COMPONENTAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPONENTEE TO ANY OTHER PERSON WITHOUT				

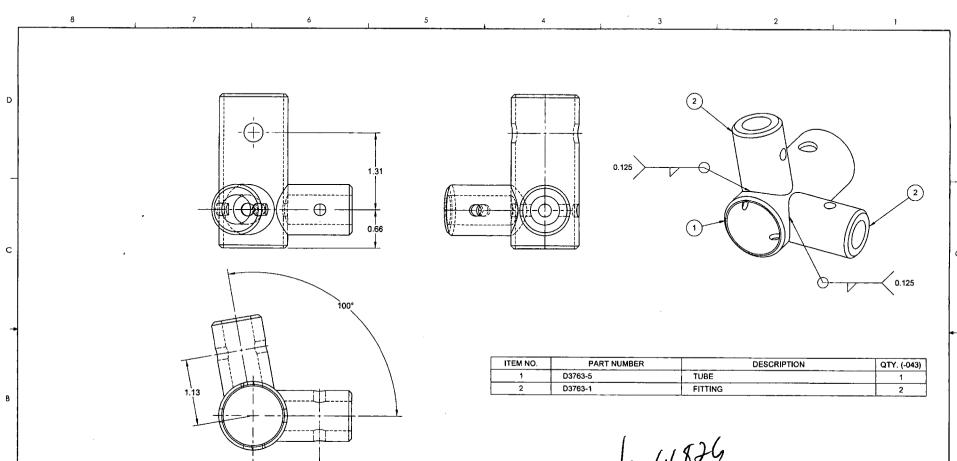
D

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

3

8

W/O:			W	ORK ORDER CHANG	ES	, ,				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								Frou Mgi		
				e e						
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	A: Date:			
	Re	esolution:	Disposition	n:	_ QA: N/C Clo	sed:	·	Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR))	;			
	STEP Description of NC Section A	Description of NC		on B	Verific	ation	Approval	Approval		
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector	
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WG 41826

D3763-043 END FITTING ASSY, LH

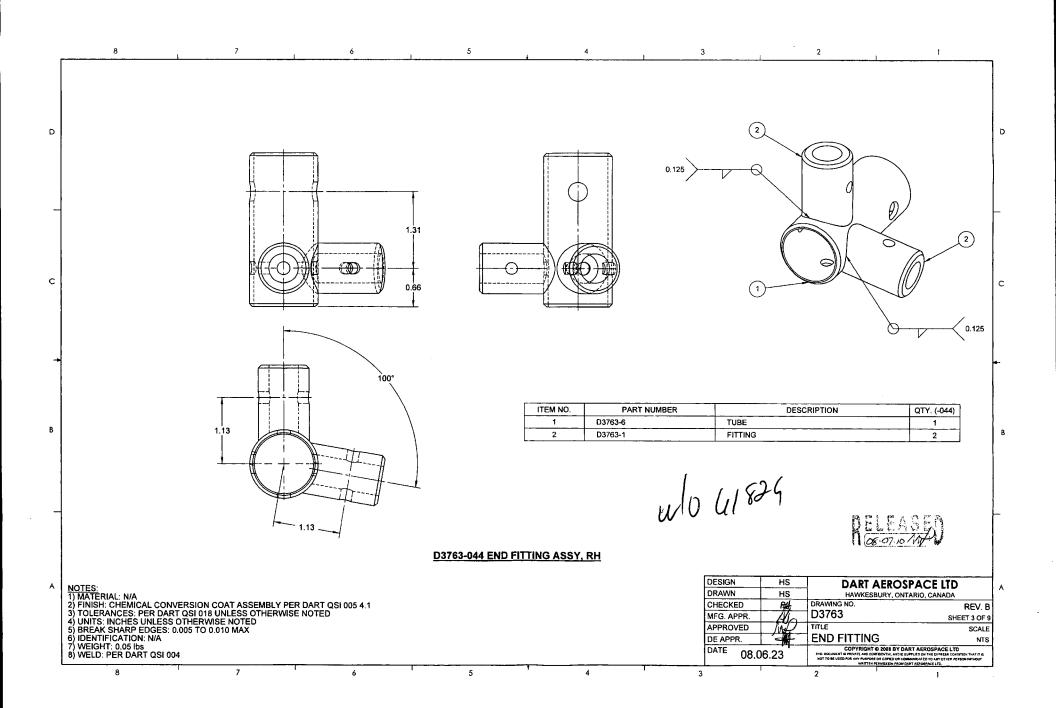
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

6) IDENTIFICATION: N/A 7) WEIGHT: 0.05 lbs 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSP	ACE LTD	
DRAWN	HS	HAWKESBURY, ONTAR		
CHECKED	RSA	DRAWING NO.	REV. B	
MFG. APPR.		D3763	SHEET 2 OF 9	
APPROVED	NAN	TITLE	SCALE	
DE APPR.	#	END FITTING	NTS	
DATE 08.0	06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS DEFINATE AND CONFIDENTIAL MID IS SUMPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO SE USED FOR MAY UNPOSE OR COMPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

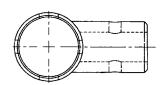
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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:	Fault Category: NCR: Yes No DQA:				Date:		
Resolution:			Disposition	QA: N/C Cld	osed:		Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A		Corrective Action Section		Verificat	tion	Approval	Approval
DATE	SIEP		Initial Actio Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng .	QC Inspector



W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	QA: Date:			
	R	esolution:	Disposition	:	QA: N/C Cld	osed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)				
	STEP Description of NC Section A	Description of NC			tion B	Verifi	cation	Approval	Approval	
DATE		Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector		
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Ø0.221 REF Ø0.323 REF — 1.13 —--



3763-7	TUBE	1
3763-1	FITTING	1
_		

DESIGN

D3763-045 END FITTING ASSY A

who 41824



NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

7) WEIGHT: 0.03 lbs 8) WELD: PER DART QSI 004

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN HS DRAWING NO. CHECKED D3763 MFG. APPR. APPROVED TITLE **END FITTING** DE APPR.

DATE 08.06.23

HS

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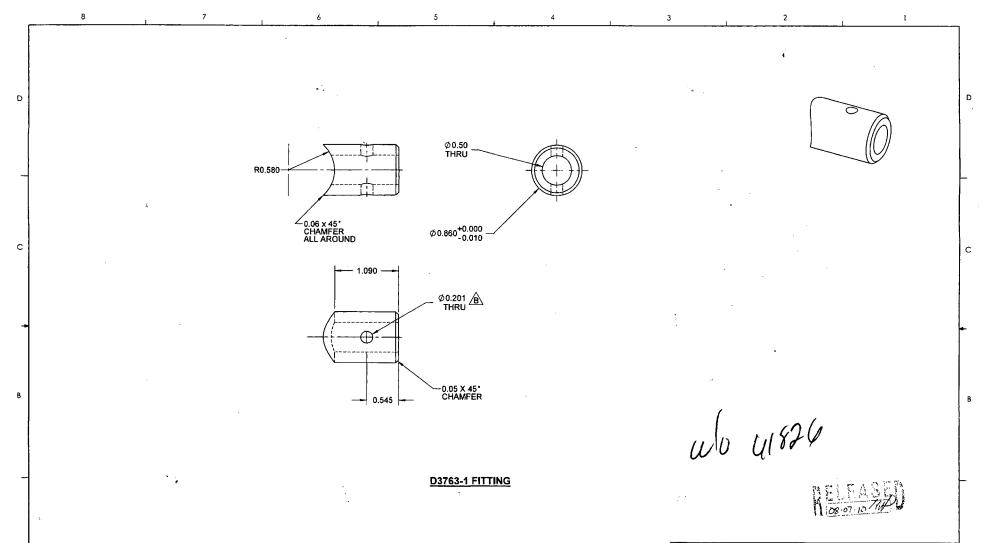
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REV. B SHEET 4 OF 9

SCALE

NTS

W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		·										
		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _				
	Resolution:							Date: _				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)						
DATE	STEP	Description of NC	I. de a	on B	Sign & Verification		Approval	Approval				
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	' Sect	ion C	Chief Eng	QC Inspector			
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NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

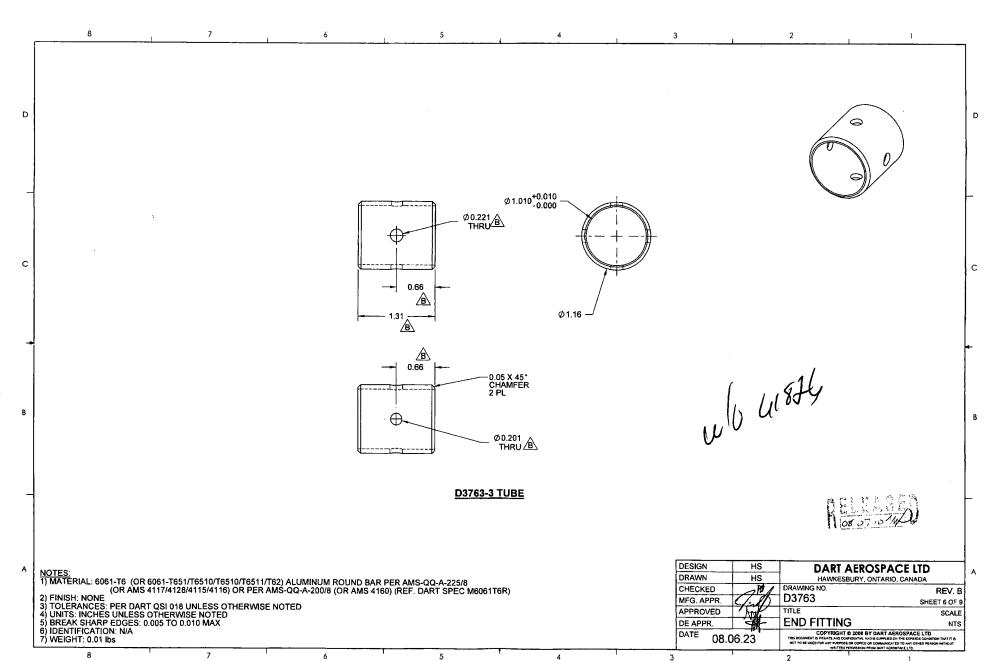
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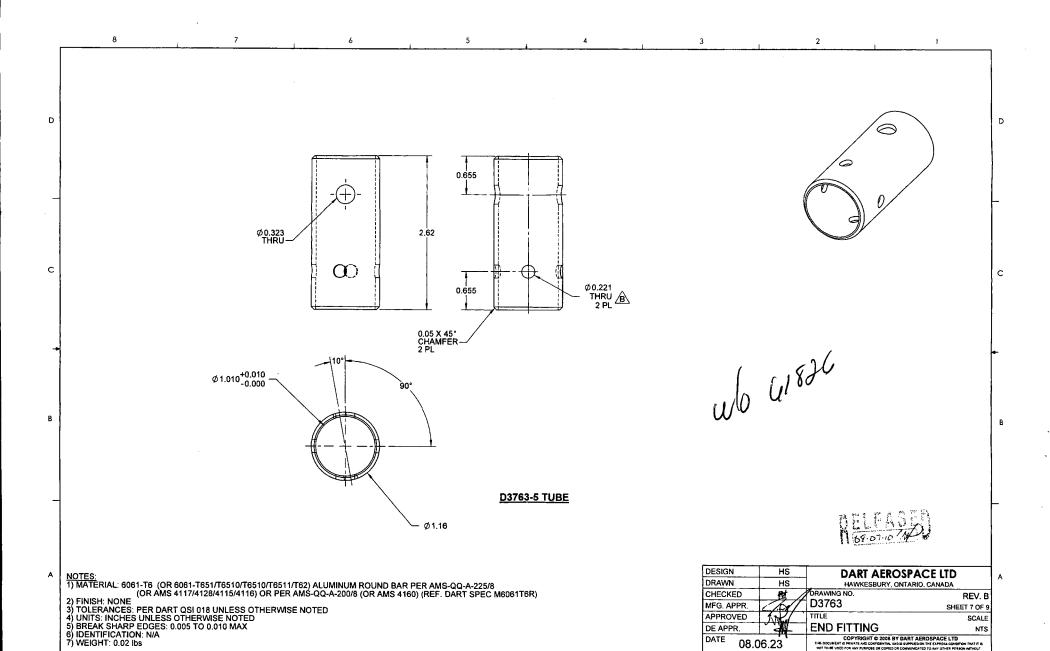
DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA HS DRAWN HS DRAWING NO. CHECKED REV. B D3763 MFG. APPR. SHEET 5 OF 9 APPROVED TITLE SCALE DE APPR. **END FITTING** NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
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W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
 												
		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
		esolution:										
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	R)						
DATE	0750	Description of NC Section A			tion B	Verific	cation	Approval Chief Eng	Approval			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti	on C		QC Inspector			
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W/O:			WC	RK ORDER CHANG	SES						
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	gory:	_ NCF	l: Yes	No D Q	A:			
	Re	esolution:	Disposition	n:	QA:	N/C Clo	sed:		Date: _		
NCR:			WORK ORDE	ER NON-CONFORM	ANCE	(NCR)				
	CTED	Description of NC			tion B		Verific	cation	Approval	Approval	
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
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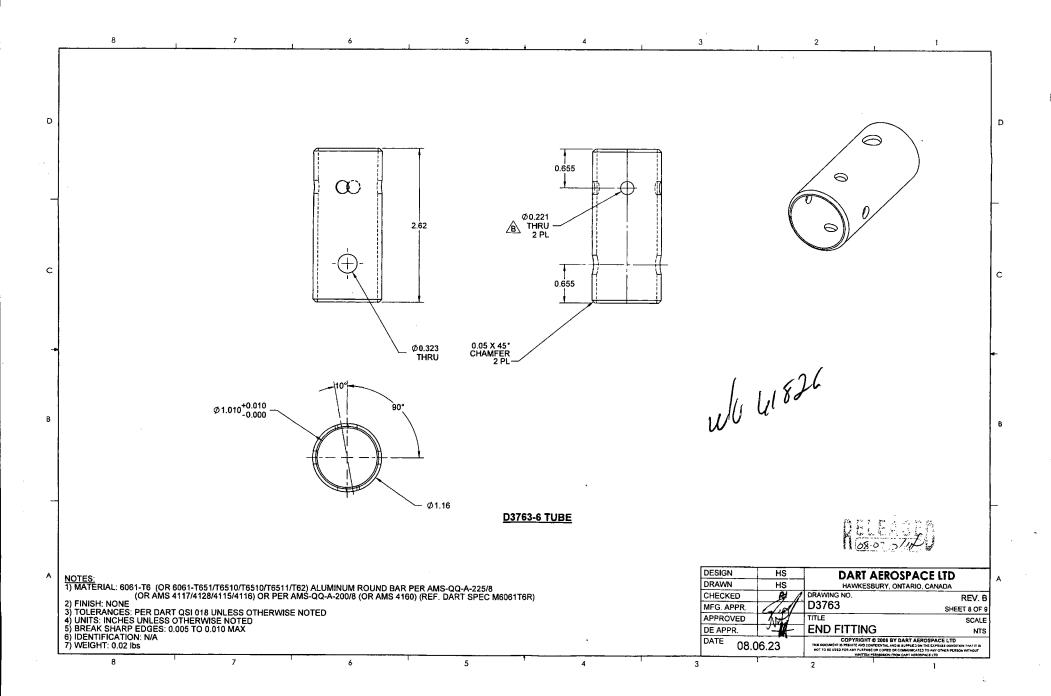
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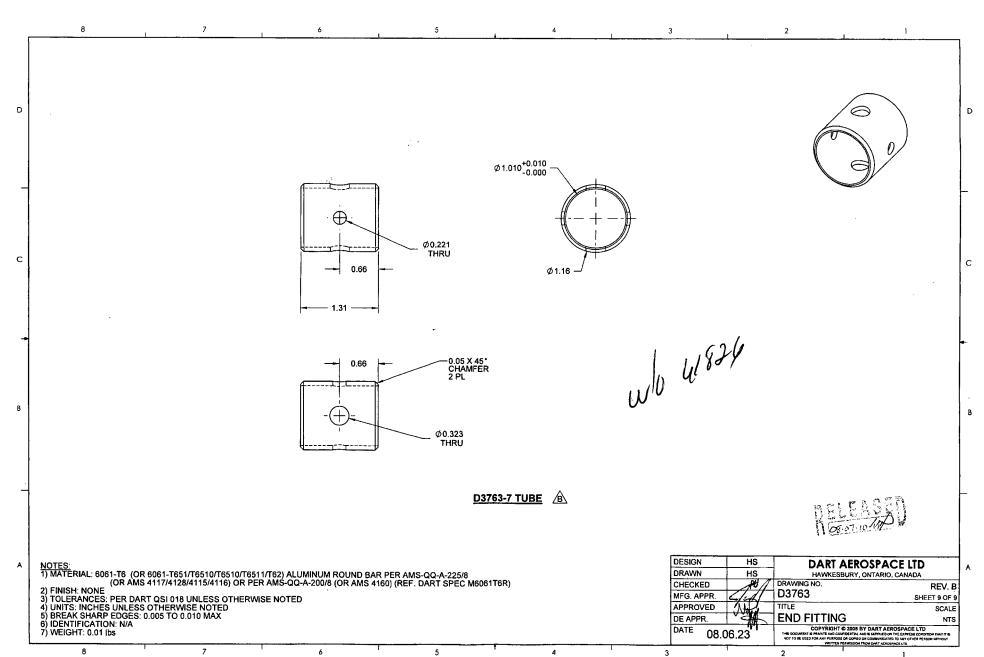
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W/O:			WO	RK ORDER CHANGI	ES					
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes No DQA: Date					
Resolution:			Disposition	1:	_ QA: N/C C	losed:		Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)				
		Description of NC Section A		Corrective Action Section		Verific	cation	Approval Chief Eng	Approval	
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	& Sect	ion C		QC Inspector	
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Dart Aeı	rospace	Ltd						•	
W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _		
Resolution:			Dispositio	n:	QA: N/C Cld	sed:	Date: _	Date:	
NCR:	· · · · · · · · · · · · · · · · · · ·		WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B		n B	Verification	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
				•					

Section A Initial Chief Eng Action Description Chief Eng Section C Chief Eng Colors and Chief Eng Colors and Chief Eng Colors and Co



W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Cat	NCR: Yes No DQA: Date:									
	R	esolution:	Dispositi	on:	QA	N/C Clo	sed:	Date:					
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE	(NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verific	ation	Approval A	Approval			
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector			
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